

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024780**Date Inspected:** 26-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

This QA Inspector received a phone call from ABF paint inspectors notifying this QA Inspector that at 2000 hours there would be a pre-blast inspection of Segment 13AE from approximately panel point 117.3 to panel point 118, side plate, south (bike path) side. Upon arrival at the location, ABF and ZPMC inspectors informed this QA Inspector that the area to be inspected was not ready and the inspection was postponed until further notice. No further notice was received during this work shift.

FCAW welding of weld joints SA7034-001-007, 008; SA7034-001-003~006; SA7034-001-001, 002. These were small parts being welded at a location on the deck of PCMK OBG 14E. Welder was identified as 050242. QC was identified as ABF CWI Cao Hai Zhou (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB, WPS-B-T-2133-ESAB, and WPS-B-T-2232-ESAB, respectively, as verbally identified by QCA1.

FCAW welding of weld joints SA7030-003~005-003, 004 located on PCMK OBG 13CE. Welder was identified as 050977. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3019E-1-162 located on PCMK OBG 14E. Welder was identified as 050242. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

SMAW welding of weld joints SEG3019V-1-245, 246 located on PCMK OBG 14E. Welder was identified as 058087. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2211-TC-U4b-FCM-1 and WPS-B-P-2211-B-U2-FCM-1, respectively, as verbally identified by QCA1.

FCAW repair welding of weld joint SEG3011-1-083 located on PCMK OBG 13CE. Welder was identified as 052696. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-FCAW-3G(3F)-ESAB-repair as displayed on ZPMC Weld Repair Report B-WR21038 as presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SEG3009D-075, 086, 090 located on PCMK OBG 13BE. Welder was identified as 055491. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

FCAW welding of weld joints FB3134-001-122, 129, 134 located on PCMK OBG 13BE. Welder was identified as 050977. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA1.

SMAW welding of weld joints AH3151A-032, 065; AH3151A-031 located on PCMK OBG 13BE. Welder was identified as 051359. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-B-U2-FCM-1 and WPS-B-P-2213-B-U2-FCM-1, respectively, as verbally identified by QCA1. See photos below of weld joint AH3151A-031 taken during a pause in the welding operation.

SMAW welding of weld joints VP3016-001-003, 004, VP3017-001-002, 003 located on PCMK OBG 14E. Welder was identified as 058102. QC was identified as ABF CWI Wang Jun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Xiang Pin (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George
----------------------	----------------

Quality Assurance Inspector

Reviewed By:	Riley, Ken
---------------------	------------

QA Reviewer
